

Work Order ID 61929-2

~~PRELIMINARY ISSUE~~

10-10-09

Thursday, September 09, 2010 12:55:29 PM

Page 1

Item ID: D4180-6
Revision ID: PRELIM
Item Name: Gusset

Accept



Setup Start
Stop



Start Date: 9/9/2010 Start Qty: 2.00
Required Date: 9/16/2010 Req'd Qty: 2.00
Reference:



Cust Item ID:
Customer:

Approvals:

Process Plan:

QC:

Handwritten initials

Date: 10-9-09 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4180

PA1

100



Waterjet

FLOW CNC Waterjet

0.00

Memo

0.00

1-Cut as per Dwg

Dwg Rev: PA1

Prog Rev: PA1

2-Deburr if necessary

10-9-13

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

④

10-9-10

Work Order ID 61929

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Page 2

Item ID: D4180-6

Accept



Revision ID: PRELIM

Setup Start



Item Name: Gusset

Stop



Start Date: 9/9/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC
Quality Control

QC8- Inspect parts - second check

0.00 - inspected to Pat

0.00 Day only
8/10/09/13 (x4)

Memo

130

Brake NC
Brake NC

Bend as per dwg

0.00

0.00

8/10/09/14 (4)

Memo

140

QC
Quality Control

QC5- Inspect part completeness to step on W/O

0.00 - inspected to Pat

0.00 Day only
8/10/09/14 (x4 -6)

Memo

Work Order ID 61929

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Page 3

Item ID: D4180-6

Accept



Setup Start



Revision ID: PRELIM

Item Name: Gusset

Stop



Start Date: 9/9/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

→ M 10/09/16

4 0

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

BR 10-9-16

0 0

170



Packaging

Packaging

Identify as per dwg & Stock Location:

composites
CA

0.00

0.00

Memo

I am

RT 10-10-0 (x3)

Work Order ID 61929

Thursday, September 09, 2010 12:55:29 PM



Page 4

Item ID: D4180-6

Accept



Setup Start



Revision ID: PRELIM

Item Name: Gusset

Stop



Start Date: 9/9/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/10/04

10-10-01

3

POSITIVE RECALL
EFFECTIVE 10-9-09 AUTH h
RELEASED A DATE 10-10-01
PER RELEASED DC4
DATED 10.09.29

Picklist Print

Thursday, September 09, 2010 12:55:33 PM

Page 1

Work Order ID: 61929

Parent Item: D4180-6

Parent Item Name: Gusset



Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6S.125 | | Purchased | No | | | 100 | sf | 125.2600 | 0.0989 | 0.208211 | | | |



6061-T6 .125 Sheet



1810-4-13

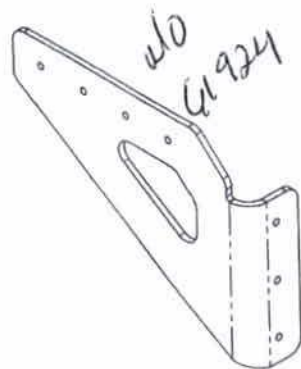
| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT21 | 125.26 | |
| 113608 | 96 | |
| 114352 | 29.26 | |

114352

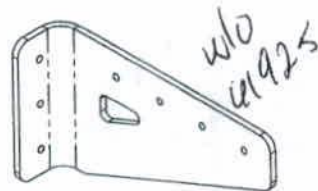
(4)

Round / Born / Ar F
 → DOME

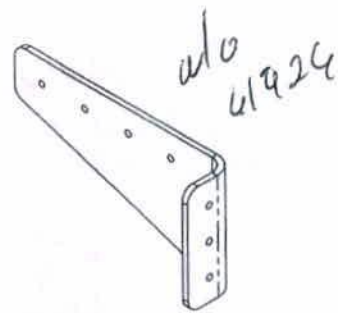
x 2 ends



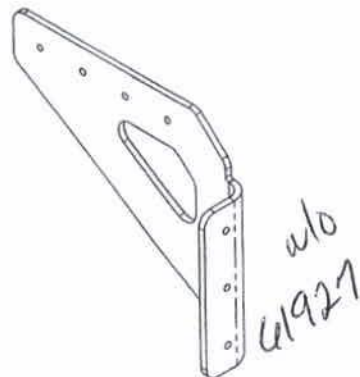
D4180-1 GUSSET



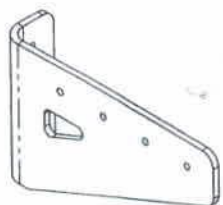
D4180-3 GUSSET



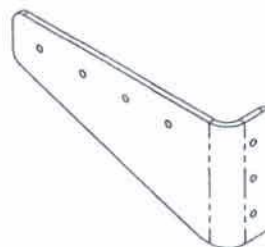
D4180-5 GUSSET



D4180-2 GUSSET



D4180-4 GUSSET



D4180-6 GUSSET

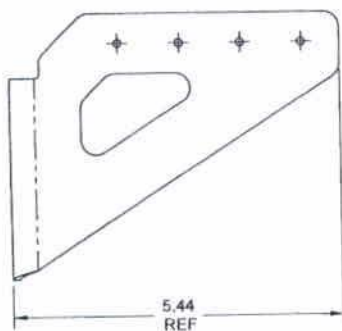
STANDARD
 RETURN TO
 HAWKESBURY
 ONTARIO L9A 4K1
 TEL: (519) 461-1111

41929
 P/109-09

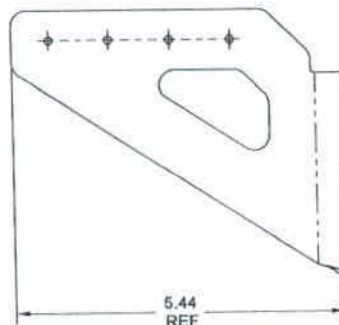
PRELIMINARY ISSUE
 10.09.08

| PA1 | NEW ISSUE | MB | 10.09.03 |
|------------|-------------|----|----------|
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.09.03 | | |

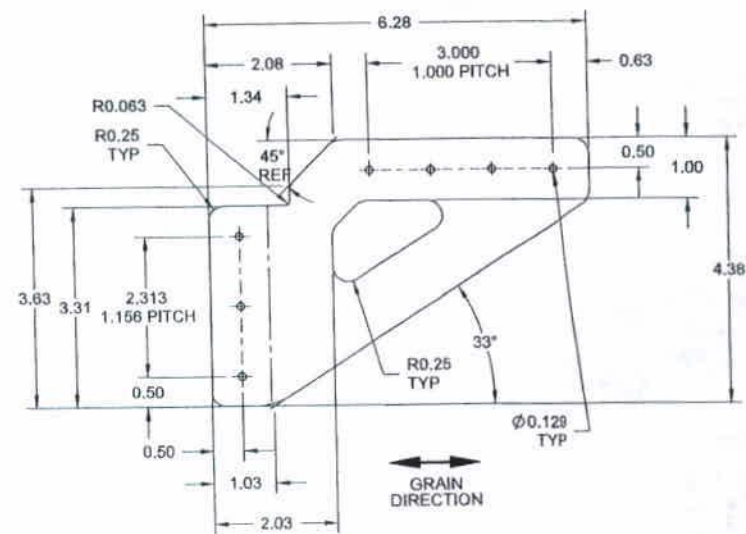
| | |
|--|--------------------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D4180 | REV. PA1 SHEET 1 OF 4 |
| TITLE POD FRAME GUSSETS | SCALE NTS |
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D4180-2 GUSSET
MAKE FROM D4180-1F



D4180-1 GUSSET
MAKE FROM D4180-1F



D4180-1F GUSSET FLAT PATTERN

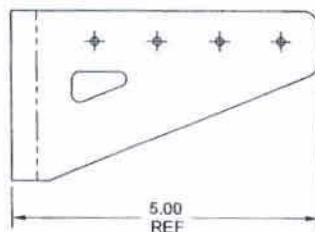
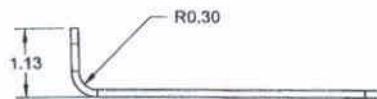
PRELIMINARY ISSUE
10.09.08

Wb 449 29

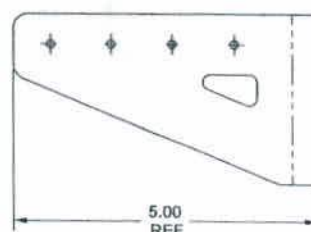
NOTES:

- NOTES:
- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.19 lbs EACH

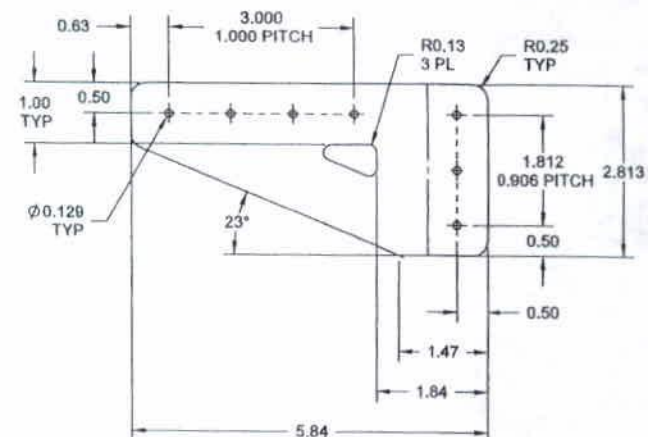
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|------------|---|--|--------------|
| DESIGN |  | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. PA1 |
| MFG. APPR. | | D4180 | SHEET 2 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR | POD FRAME GUSSETS | | NTS |
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D4180-4 GUSSET
MAKE FROM D4180-3F



D4180-3 GUSSET
MAKE FROM D4180-3F



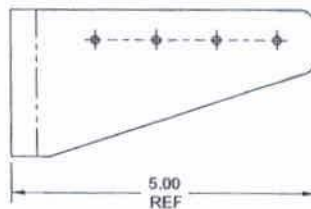
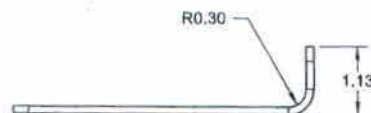
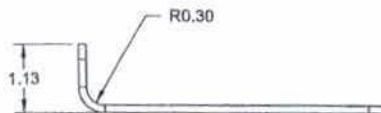
D4180-3F GUSSET FLAT PATTERN

w/o 01929

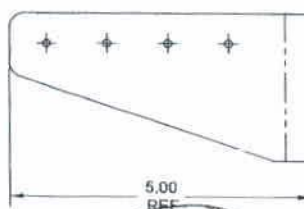
PRELIMINARY ISSUE
10.09.08

- NOTES:**
- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M0661T6S.125
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.15 lbs EACH

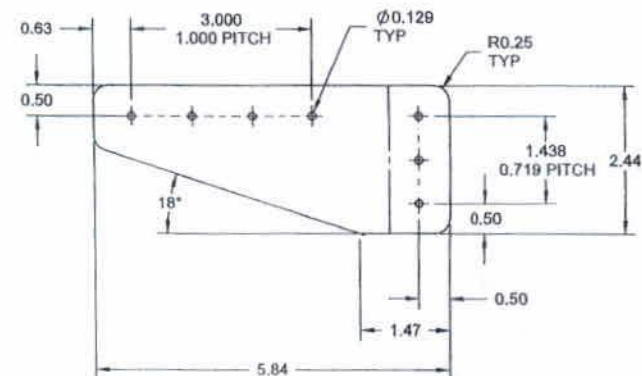
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| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. PA1 |
| MFG. APPR. | | D4180 | SHEET 3 OF 4 |
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D4180-5 GUSSET
MAKE FROM D4180-5F



D4180-6 GUSSET
MAKE FROM D4180-5F



D4180-5F GUSSET FLAT PATTERN

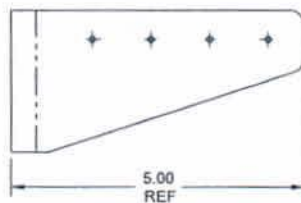
W/O 61929

PRELIMINARY ISSUE
10.09.08

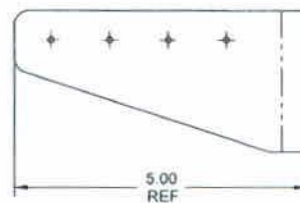
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M8061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs

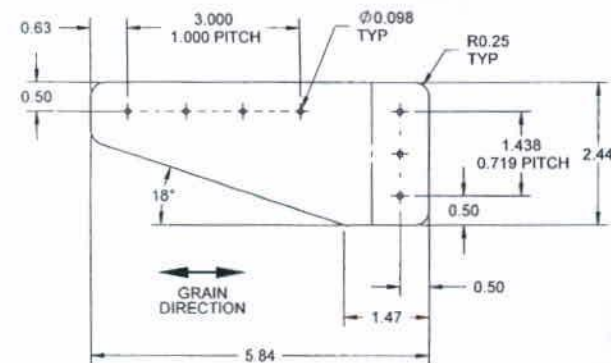
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| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. PA1 |
| MFG. APPR. | | D4180 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | POD FRAME GUSSETS | NTS |
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D4180-5 GUSSET
MAKE FROM D4180-5F



D4180-6 GUSSET
MAKE FROM D4180-5F



D4180-5F GUSSET FLAT PATTERN

NOTES

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs

| | | | |
|---|----------|--|--------------|
| DESIGN | J1 | DART AEROSPACE LTD | |
| DRAWN | J1 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | J1 | DRAWING NO. | REV. A |
| MFG. APPR. | J1 | D4180 | SHEET 4 OF 4 |
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RELEASED
2010-09-29

61929